

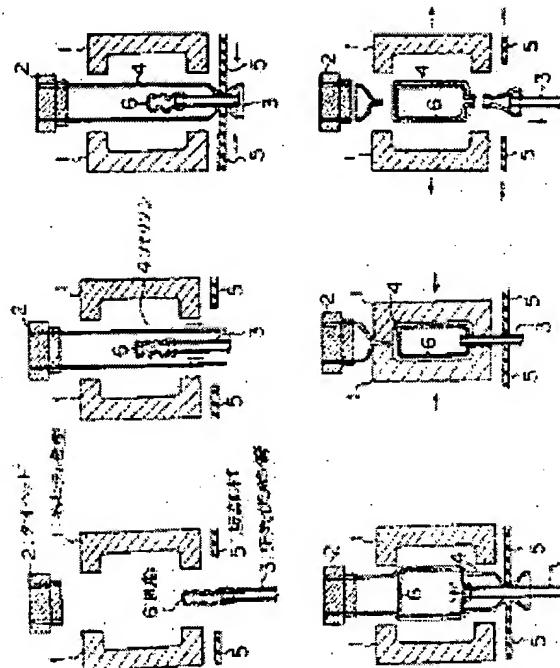
BLOW MOLDING METHOD

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Abstract of JP1069325

PURPOSE: To obtain a molding of a uniform thickness in blow molding, by a method wherein a balloon is inserted into a parison by injecting the parison to a cavity mold through a die head mounted by facing on an air feed pipe, the parison is premolded by feeding air within the balloon and main molding is performed by performing mold clamping.
CONSTITUTION: A balloon 6 which has been processed so that an outside form of the said balloon becomes the outside form of a molding when air is blown into the balloon is connected to the tip of an air feed pipe 3. When plasticized parison 4 is extruded through a die head 2 under a state where cavity molds 1, 1 and plate members 5, 5 are separated from one another and the lower end of the parison 4 is extruded down to a lower side than the plate member 5, extrusion is suspended. A part close to the lower end of the parison and air feed pipe 3 are held by placing them between the two plate members 5, 5 by making them approach each other. When the air is blown into the balloon 6, the balloon 6 is expanded while coming into contact with the parison 4 and the parison is premolded into the outside form of the molding. The cavity molds 1, 1 are clamped by making them approach each other, the parison 4 is quenched and cured through the cavity mold 1, the balloon 6 expanded after the outside form of the molding is stuck to an inner wall of the parison and molded integrally.



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